

Date: Thursday, 10/04/2008 4:00:36 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID RH
Job Number : 38538	
Estimate Number : 10720	
P.O. Number :	Part Number : D350591214
This Issue : 10/04/2008 S.O. No. :	Drawing Number : D3078 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 38092	Material :
Written By :	Due Date : 28/04/2008 Qty: 5 Um: Each
Checked & Approved By : <u>JLO 08.4.10</u>	
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-214 CHG002

S 08/05/09 8.4.21

2.0	D2622120C
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**Comment:** Qty.: 0.50000 Each(s)/Unit Total : 2.50000 Each(s)

Pick:

Qty Part Number Description Batch

.5 D2622-120

Extrusion

36923

SAD 08/04/28

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SAD 08/04/28 (5)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 08/04/28 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D30671	
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Comment: Qty.: 1.00000 Each(s)/Unit Total: 5.00000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate 337571

PL 08.04.28 5

6.0	D30631	
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Comment: Qty.: 1.00000 Each(s)/Unit Total: 5.00000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support 335691

PL 08.04.28 5

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M106834
M106762

3-Grind End Plate flush

PL 08.04.28 5

PL 08.04.28 5

SAP 08/04/29 5

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PL 08-01-30 (5)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PL 08/04/30 (5) RH

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/04/30 (5) RH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-01

(X)

12.0	D3065041	
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Comment: Qty.: 1.00000 Each(s)/Unit Total: 5.00000 Each(s)

Pick:

Qty Part Number	Description	Batch
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1 D3065-041	Step Leg Assy	35626
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SAD 08/05/01

(5)

13.0	D30661	
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Comment: Qty.: 2.00000 Each(s)/Unit Total: 10.00000 Each(s)

Pick:

Qty Part Number	Description	Batch
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2 D3066-1	Spacer	38150
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SAD 08/05/01

(5)

14.0	MS20600AD4W4	
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Comment: Qty.: 16.00000 Each(s)/Unit Total: 80.00000 Each(s)

Pick:

Qty Part Number	Description	Batch
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16 MS20600AD4W4	Rivet	107756
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SAD 08/05/01

(5)

15.0	LARGE FAB 1	
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Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD 08/05/01

(5)

16.0	QC5	
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INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0805/01 (XSRH)

17.0	D30671	
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Comment: Qty.: 1.00000 Each(s)/Unit Total: 5.00000 Each(s)

Pick:

Qty Part Number	Description	Batch
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1 D3067-1	End Plate	337571
-----------	-----------	--------

08-05-5 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350591214

Job Number:



Seq. #: Machine Or Operation: Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

✓ 1-Bevel Aft end for welding

✓ 2-Inspect for foreign object as per QSI 024

✓ 3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod *M106834*

4-Grind End Plate flush

FL 08.05.05 5

FL 08.05.05 5

FL 08.05.05 5

SAD 08/05/05 (5)

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08.06.05 (5)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/06 (5) SKD

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

FL 08/05/08

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

FL 08.05.05 YORH

*338538
D350591214
08/05/2008
08.49
#1 321.5 F
#2 30m/10 F
#3 --- F*

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

M107380

FL 08/05/08 (5)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

M-1 08/05/05 (5X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 38538

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22303



Comment: Qty.: 2.00000 Each(s)/Unit Total : 10.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

37918

37918

27.0

D22301



Comment: Qty.: 2.00000 Each(s)/Unit Total : 10.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

38740

28.0

D2732



Comment: Qty.: 1.00000 f(s)/Unit Total : 5.00000 f(s)

Rubber Extrusion

4 X 3"

Batch:

37632

29.0

D2856400



Comment: Qty.: 0.60000 f(s)/Unit Total : 3.00000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

36161

30.0

AN335A



Comment: Qty.: 2.00000 Each(s)/Unit Total : 10.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A

Bolt

106993

8/5/7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 38538

Part Number: D350591214

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0

AN411A



Comment: Qty.: 6.00000 Each(s)/Unit Total : 30.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A

Bolt

104214

SP

32.0

AN413A



Comment: Qty.: 4.00000 Each(s)/Unit Total : 20.00000 Each(s)

Bolt

Batch:

107534

SP

33.0

AN960JD10



Comment: Qty.: 4.00000 Each(s)/Unit Total : 20.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

107715

SP

34.0

AN960JD416



Comment: Qty.: 12.00000 Each(s)/Unit Total : 60.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

107321

SP

35.0

MS21042L3



Comment: Qty.: 2.00000 Each(s)/Unit Total : 10.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

107644

SP

36.0

MS21042L4



Comment: Qty.: 6.00000 Each(s)/Unit Total : 30.00000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

106051

8/5/17

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				/			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 38538

Part Number: D350591214

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/09 (SRH)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location: _____

PPP Rev: _____

Rev D

AS 08/05/09 (SRH)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/12 JJ

Job Completion



mf 08-05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.09.20

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CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. 38538

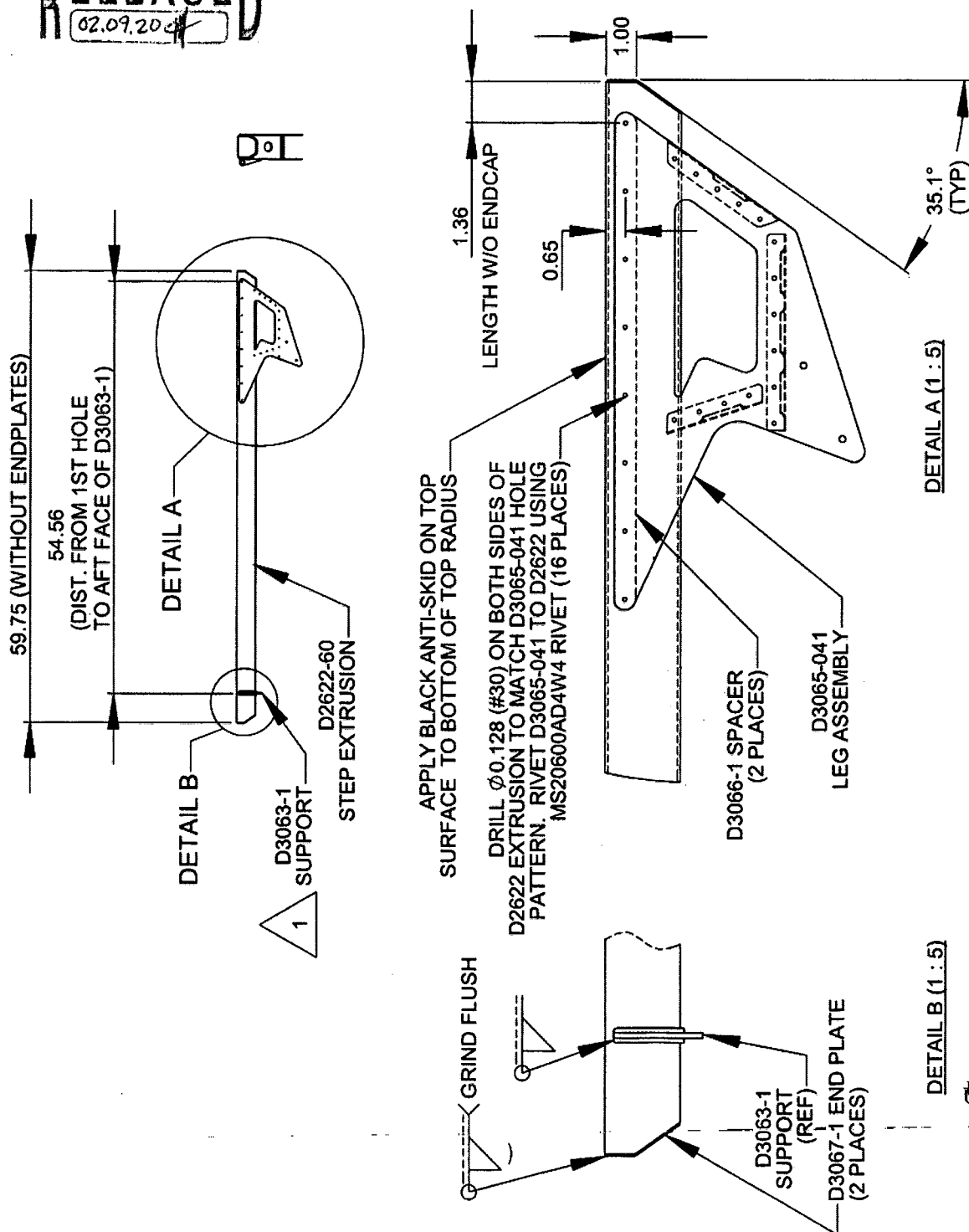
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 2 OF 2
DATE 02.09.11	TITLE STEP ASSEMBLY, HI SHORT		SCALE 1:20

RELEASED
02.09.2011



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